



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

RBW6305G19631-3G-25
Job Sheet 176722



Part No: RBW6305G19631-3G-25 **Job Qty:** 4 ea

Part Name: Tool Layout Placard



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/30/18

Job Tracking No:

Due Date: 5/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6305G19631-3G Rev 3 IPP Rev A 18.03.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/3/18	0.00	0.00	Start Up Small Fab-3		MCC
110	Small Fab	4 pcs		5/3/18	0.00	1.63	Small Fab-4		MCC
120	QC	4 pcs		5/3/18	0.00	0.00	QC5		SB
130	Packaging	4 pcs		5/3/18	0.00	0.00	Packaging3-1		APR 30 2018
140	QC21-SA	4 Ea		5/3/18	0.00	0.00	QC21		GA098

Part Op 110 - 1-Engrave placard using Laser engraver as per DWG. Sheet 5. ***NOTE*** Use PDP

Descriptions: 120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
LM922402	Plastic, Black & White	1.2840 sf (.321 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	LM922402	1	38	0

Part Specifications

Specifications could not be found.

Plex 4/30/18 8:51 AM Dart.lajeunesse.marie

9.26 x 6.00

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

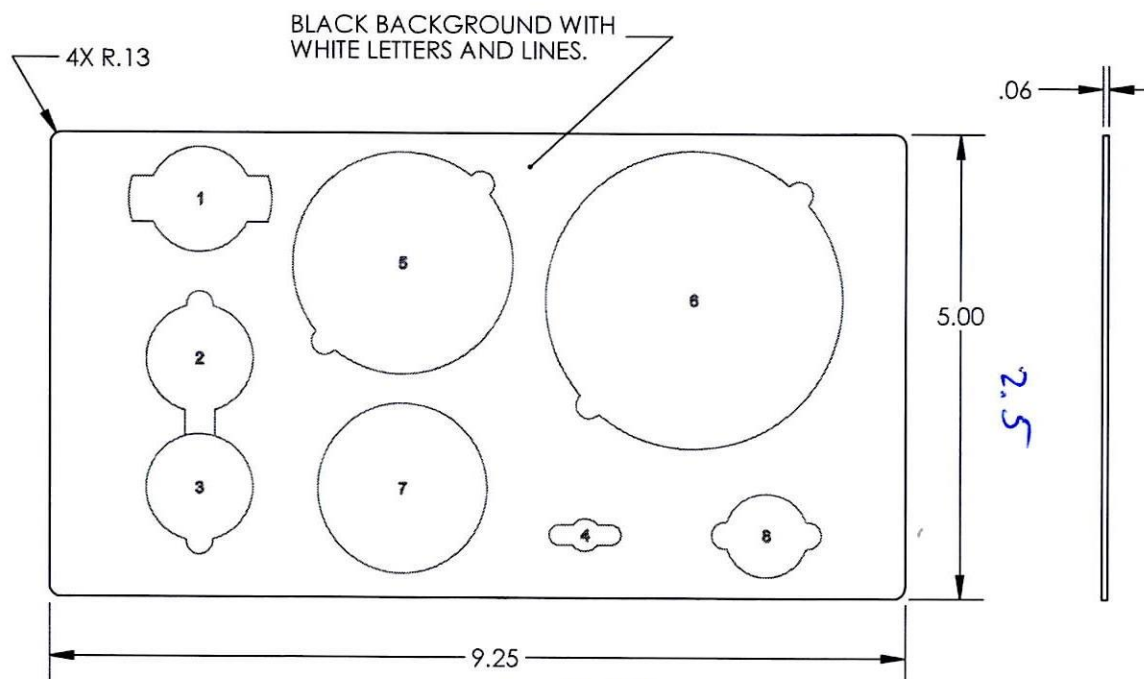
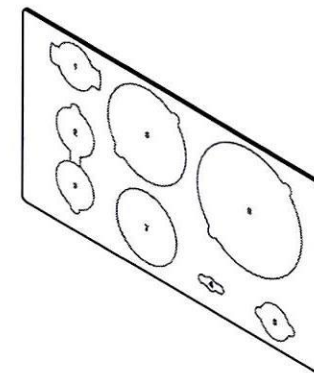
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Date : _____ Step #: _____ S <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Jet</td> <td style="width: 33%;">Engineering</td> <td style="width: 33%;"></td> </tr> <tr> <td>or.</td> <td>Quality</td> <td></td> </tr> <tr> <td>ng</td> <td>Other</td> <td></td> </tr> <tr> <td>er</td> <td></td> <td></td> </tr> </table>		Jet	Engineering		or.	Quality		ng	Other		er																																						
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Description Work Order Deviation				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																	
Root Cause <table border="0" style="width: 100%;"> <tr> <td style="width: 33%;">Environment ☐</td> <td style="width: 33%;">No Re-verification ☐</td> <td style="width: 33%;">Pressure/Forced ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> </tr> </table>		Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐		<table border="0" style="width: 100%;"> <tr> <td style="width: 33%;">Ten ☐</td> <td style="width: 33%;">Tensile ☐</td> <td style="width: 33%;">Tensile ☐</td> </tr> <tr> <td>Set- ☐</td> <td>BOM ☐</td> <td>Brok ☐</td> </tr> <tr> <td>Inspe ☐</td> <td>Cont: ☐</td> <td>Count ☐</td> </tr> <tr> <td>Cut Tc ☐</td> <td>Instruc ☐</td> <td>Drill Holes ☐</td> </tr> </table>		Ten ☐	Tensile ☐	Tensile ☐	Set- ☐	BOM ☐	Brok ☐	Inspe ☐	Cont: ☐	Count ☐	Cut Tc ☐	Instruc ☐	Drill Holes ☐	Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence	
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 Container No: S066926
 Part: RBW6305619631-3G-25
 Job No: 176722
 Serial No/Batch: S066926
 Inspector: 3
 Date: 04/30/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2A		CH'D -25 WAS B/O IS MANUFACTURED.	10/30/2013	CFS	RJC
3	17-0138	-25 CHD DIM WAS R.37 (x4) IS 4X R.13. WAS 5.50 IS 5.00. ADDED USE PDF NOTE. DELETED TEXT ARIAL, 1/8 LETTERS. CH'D TOLERANCE WAS .XXX ±.005 .XX ±.01 IS .XXX ±.010 XX ±.03.	6/13/2017	RJC	JAG



NOTE:
USE PDF.



TITLE
MAIN ROTOR DRIVE TOOL KIT 1

DWG NO. RBW6305G19631-3G-25 REV 3

MAT'L PLASTIC		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ±1°	
DRAWN BY: RJC 06/13/2017		.X ± .1 SURFACES = 125/	
CHECKED: DD 06/14/2017		1. BREAK ALL SHARP EDGES	
OPPS APPR: AA 06/14/2017		.015 x 45° OR .015R	
QA APPR: JL 06/28/2017		2. DIMENSIONAL LIMITS APPLY	
APPROVED: JAG 07/07/2017		AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER	
DATE 6/13/2017		ASME Y14.5M-2009	
SHEET 5 OF 5		USED ON MODEL	
		AW139	

(-25)

TOOL LAYOUT PLACARD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								